



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2850-1

Job Sheet 186911



Part No: D2850-1

Job Qty: 10 ea

Part Name: End Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/22/18

Job Tracking No:

Due Date: 11/30/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP B 98.12.07 Changed folio DM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	11/30/18	11/30/18	0.00	0.00	Start Up Machining-1		<i>DJP 18-11-29</i>
100	Bandsaw	10 pcs	11/30/18	11/30/18	0.00	0.08	Bandsaw1		<i>DJP 18-11-29</i>
110	CNC Vertical Machining	10 pcs	11/30/18	11/30/18	0.20	6.99	HAAS1-2		<i>DJP 18-11-29</i>
130	QC	10 pcs	11/30/18	11/30/18	0.00	0.00	QC8 Machining-1		<i>18/12/01</i>
140	Packaging	10 pcs	11/30/18	11/30/18	0.00	0.00	Packaging3-1		<i>18/12/01</i>
150	QC21-SA	10 Ea	11/30/18	11/30/18	0.00	0.00	QC21		<i>21 9-88</i>

Part Op 100 - Cut blanks: 3.8"

Descriptions: 110 - Machine per Folio D2850-1 Deburr and Tumble

140 - *** STOCK IN STEP CELL ***

DEC 03 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B2.500X01.500	6061-T6 Bar 2.50 X 1.50	3 ft (.3 ea)	90-Start up Operation	<i>5124463</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B2.500X01.500	3	48	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	High Float Step End Bracket	1.720inches + 0.000 - 0.030	1.720 1.690	<i>1.720</i>	
2	High Float Step End Bracket	0.178inches ± 0.010	0.188 0.168	<i>0.173</i>	
3	High Float Step End Bracket	0.100inches ± 0.030	0.130 0.070	<i>0.101</i>	
4	High Float Step End Bracket	30.000Degrees ± 0.500	30.500 29.500	<i>30°</i>	
5	High Float Step End Bracket	2.150inches ± 0.030	2.180 2.120	<i>2.150</i>	
6	High Float Step End Bracket	0.375inches + 0.010 - 0.100	0.385 0.275	<i>0.372</i>	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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8	High Float Step End Bracket	1.000inches $\pm$ 0.030	1.030 0.970	1.003
9	High Float Step End Bracket	0.125inches $\pm$ 0.010	0.135 0.115	0.126
10	High Float Step End Bracket	19.200Degrees $\pm$ 0.500	19.700 18.700	19.2
11	High Float Step End Bracket	0.125inches $\pm$ 0.010	0.135 0.115	0.126
12	High Float Step End Bracket	0.750inches $\pm$ 0.010	0.760 0.740	0.750
13	High Float Step End Bracket	0.600inches $\pm$ 0.010	0.610 0.590	0.604

DIP 18-11-29

Plex 11/22/18 1:05 PM Dart.lajeunesse.marie



Container No: S133680



Part: D2850-1

Job No: 186911

Serial No/Batch: S133680

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.

1270 Aberdeen Street

Hawkesbury, ON K64 1K7

CANADA

TEL.: 1 613 632-5200

Email: sales@dartaero.com

www.dartaerospace.com

Date: 12/01/18

DQA: _____ Date: _____



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Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

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